

WORK ORDER 2010-05

Date opened: 17 February 2010

Project: Quick Release Cargo Basket Assembly  
Type: Bell 206BBatch Quantity: 1 Complete Basket Assembly (81110-01)  
Modified with Lid StepApproval: SH09-5  
Drawing List: DCL811-3

<u>Fabrication and Assembly Drawing(s)</u>	<u>Description</u>
81110, Rev. 0	Basket Ass'y
81111, Rev. 0	Basket Body Ass'y
81112, Rev. 0	Basket Lid Ass'y
84255, Rev. 0	Handle Installation
84261, Rev. 0	Handle Bar Ass'y
84262, Rev. 0	Handle Bracket Ass'y
70406 Rev. 2	<del>Front End Cutout</del> LID STEP

Complete material tracking information on attached pages.

## Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y</u> ✓
Document Control List revision level matches (or exceeds) STC:	<u>Y</u> ✓
Drawings revision levels match Document Control List:	<u>Y</u> ✓
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y</u> ✓
Tests and inspections specifically called out on drawings are complete:	<u>Y</u> ✓
Release tags associated with all fabricated parts are attached:	<u>Y</u> ✓
All mounting hardware and supplies are included:	<u>Y</u> ✓

List all non-conformities raised: \_\_\_\_\_

Welder Signature: \_\_\_\_\_

Date: \_\_\_\_\_

Inspector Signature: \_\_\_\_\_

02 Feb 2012  
Date: \_\_\_\_\_

Drawing: 81110 Revision 0  
 Assembly: 81110-01 Cargo Basket Ass'y (Quick-Release, Long)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	81110-01	Cargo Basket Assembly			
1	81111-01	Basket Body Assembly	Below		
1	81112-01	Basket Lid Assembly	Below		
1	84255-01	Handle Bar Installation	Below		
1	36280-01	Brace Assembly	9-2081 Brace	8083	
1	MS20001P4	Piano Hinge		8104	
1	81127-01	Placard	0.063 Sheet, 6061-T6 Aluminum	8062	
3	49205-14	Bumper	Argus Industries Bumper	16026	
A/R	CR3213-5-02	Cherry Rivet		10089	
A/R	CR3523-5-02	Cherry Rivet		10064	
4	40088-14	Fitting	Ancra	10006	
4	AN960-616	Washer		10017/10025	
1	AN3-15A	Bolt		7077	
1	AN3-17A	Bolt		7077	
4	AN960-10	Washer		10049	
2	AN970-3	Washer		8067	
2	MS21044N3	Nut		10025	

Processes	Per	Mat'ls Used	Inspection	Signature
Riveting	AC43.13-1B	Cherry Rivets		JC
Final Inspection	Drawing 81110			JC

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 81111 Revision 0  
 Assembly: 81111-01 Basket Body Ass'y (Quick-Release, Long)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	81111-01	Basket Body Assembly			
4	80322-01	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	9057	
2	80324-01	Attachment Hoop	4130 Steel, 1.0 x 0.065 Sqr. Tube	8007	
A/R		Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	8097	
A/R		Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	9057	
1	84262-01	Handle Bracket Assembly	Below		
1	49215-01	Spacer	1018 Steel, 1/2" Rod	7007	
A/R	3/4-16F	Mesh	Expanded carbon steel	5094	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 81111			JC.
Final Inspection	Drawing 81111			JC.

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Drawing: 81112 Revision 0  
Assembly: 81112-01 Basket Lid Ass'y (Quick-Release, Short, 57.25" long)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	81112-01	Basket Lid Assembly			
A/R		Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	8064	
1	49216-01	Spacer	1018 Steel, 1/2" Rod	7007	
1	84262-01	Upper Handle Bracket Assembly	Below		
1	36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	9010	
A/R	3/4-16F	Mesh	Expanded carbon steel	8094	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 81112			
Final Inspection	Drawing 81112			

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Drawing: 84255 Revision 0  
Assembly: 84255-01 Handle Installation

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	84255-01	Handle Installation			
1	84261-01	Handle Bar Assembly	Below		
2	84267-01	Bracket	3/4" Delrin Sheet	wo 2007-21	
2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	9091	
2	36275-01	Bushing	SAE 660 Bronze, 5/16" Dia	6068	
4	AN3-11A	Bolt		10049	
2	AN3-12A	Bolt		10082	
12	AN960-10	Washer		10082	
6	MS21044N3	Nut		10049	

Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 84255			<i>JK.</i>

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Drawing: 84261 Revision 0  
Assembly: 84261-01 Handle Bar Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	84261-01	Handle Bar Assembly			
1	36277-01	Handle Bar	316 Stainless, 1.0 x 0.035 Rnd. Tube	10083	
2	36271-01	Lever	304 Stainless, 0.105 Sheet	10036	
2	36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	8076	
2	MS20615-4M3	Rivet		7039	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84261			jc

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Drawing: 84262 Revision 0  
Assembly: 84262-01 Handle Bracket Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	84261-01	Handle Bracket Assembly			
4	84272-01	Bushing	4130 Steel, 5/16 x 0.058 Tube	6076	
4	36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	10037	
2	36275-02	Support	304 Stainless, 5/16" Rod	8065	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84262			jc.

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Drawing: 70405 Revision 2  
Assembly: 70405-01 Lid Step Modification

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	70405-01	Lid Step Modification			
A/R	70405-03	Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	9057	
1	70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	9054	
A/R	CR3213-4-2	Cherry Rivet		9078	


Note: Remainder of assembly listed on drawing 81112.

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Final Inspection	Drawing 70405			je.

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Tag complete parts / assemblies with Release Tag prior to storage.



1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 2013 39 <sup>th</sup> Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice WO 2010-05
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	Long Cargo Basket	81110-01	1	81101-04	New
12. Remarks Modified with Lid Step in accordance with DCL704					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke		13e. Date (dd/mmm/yyyy) 02 Feb 2012		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p style="text-align: center;"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

CAP 1174